Date:

Tuesday, 10/06/2008 3:14:32 PM

User:

Julie Lecocq

#### **Process Sheet**

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 39805

**Estimate Number** 

: 10175

P.O. Number

This Issue

: 10/06/2008 : NC

Prsht Rev. First Issue

**Previous Run** 

: // : 39369

S.O. No. :

Type

: MACHINED PARTS

08.6.10

**Part Number** 

**Drawing Name** 

: D2570 . D2570 REV B

**Drawing Number** 

: N/A Project Number : B

**Drawing Revision** Material

**Due Date** 

: 23/06/2008

: BUSHING

Qty:

500 Um:

Each

Written By

Checked & Approved By Comment

: Est E 02.08.29

Re-format; Removed finishing; Material change K

est F 07.07.06

rev B dwg

EC

**Additional Product** 

Job Number:



Seq. #:

**Machine Or Operation:** 

**Description:** 

1.0

M303R0750

303 Round Bar .75"



Comment: Qty.:

0.0810 f(s)/Unit Total:

Material: Ø0.750 AISI 303 SS Rod (M303R0.750)

Machine as per folio FA198

Batch M 10820

2.0

HARDINGE



Comment: HARDINGE CNC LATHE SMALL

Deburr

3.0 QC2







Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK





Comment: SECOND CHECK



5.0

**PACKAGING 1** 

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

W/O:	WORK ORDER CHANGES					:				
DATE	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
		1	7		117					
D (N										

Part No:	_PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C	Closed:	Date:

NCR:		,	WORK ORE	DER NON-CONFORMANO	E (NCR)			
		Description of NC		Corrective Action Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date			
				·				
•			(1)					
				(4)				

Date:

Tuesday, 10/06/2008 3:14:33 PM

Use::

▶ Julie Lecocq

**Process Sheet** 

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39805

Part Number: D2570

Job Number:



Seq. #:

**Machine Or Operation:** 

Description:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:			WORK ORDER	CHANGES							
DATE	STEP	PR	OCEDURE CHANGE		Ву	Date	Qty Approval Chief Eng / Prod Mgr	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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Part No		DAD #.	Fault Catagony			N. DO	_	Data			

Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
•			QA: N/C Closed:	Date:
NCR:		WORK ORDER NON-CON	IFORMANCE (NCR)	
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NCR:												
		Description of NC	Corrective Action Section B			Verification	Approval	Approval				
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector				
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DART AEROSPACE LTD	Work Order:	39805
Description: Bushing	Part Number:	D2570
Inspection Dwg: D2570 Rev: B		Page 1 of 1

#### FIRST ARTICLE INSPECTION CHECKLIST

X	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	,601	V			
0.060	+/-0.005	.062	v/			
R0.010	+0.010/-0.000	20.00	1			
Ø0.425	+0.000/-0.002	NEP, CS	V			
Ø0.257	+0.005/-0.000	0.257	/			
Ø0.750	+/-0.010	Ø.749	V			
0.030 x 20°	+/-0.010	.030 × 20°	V			
	. "					:
						•
· ·						

Measured by: MM=/9m/	Audited by:	J.L.	Prototype Approval:	N/A	4
Date: 08/06/13	Date:	08/06/18	Date:	J	Α

Rev	Date	Change	Revised by	Approved
Α	03.12.08	New Issue	KJ/RF	
В	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
С	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM OK	B

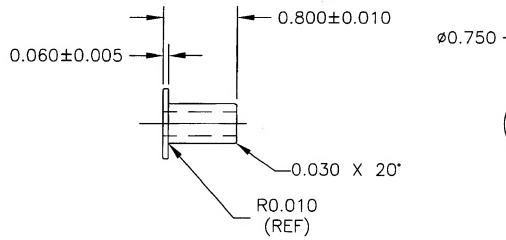
W/O:		WORK ORDER CH	ANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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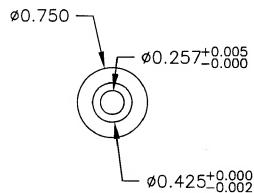
Part No:	PAR #:	Fault Category: _	 NCR: Yes No	DQA:	Date:
	,		QA: N/C	Closed:	Date:

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC	Corrective Action Section B Verification				Approval	<b></b>	
DATE STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector		
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O	esign <i>PH</i>	DRAWN BY	DART AEROSP, HAWKESBURY, ONTARI	
C	HECKED	APPROVED	DRAWING NO.	REV. B
	世	H	D2570	SHEET 1 OF 1
D	ATE	-	TITLE	SCALE
C	7.04.17		BUSHING	1:1
	Α	96.09.16	NEW ISSUE	
	В	07.04.17	UPDATE NOTES	





#### D2570 BUSHING

#### D2570 BUSHING

MATERIAL: 1)

AISI 303 ROUND BAR (REF. DART SPEC. M303R)

2) FINISH:

NONE

- 3) ALL DIMENSIONS ARE INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 4)
- BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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W/O:		WORK ORDER CHANGES								
DATE	STEP	14		PROCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No:	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
	1.00		QA: N/C Closed:	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section	Verification	A	A	
DATE STEP	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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